

Work Order ID 68648



Page 1

Tuesday, April 19, 2011 1:31:09 PM

Item ID: D3391-023

Accept



Setup Start



Revision ID:

Item Name: Mid Tube Assembly

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 11-04-19 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								
100	Skidtubes	0.00							



Skidtubes

Skidtubes

Memo

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

SCRAP

11-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: D3391-023 PAR #: Fault Category: Weld tubes NCR: Yes No DQA: *AS* Date: 11.06.09
 Resolution: *Scrap* Disposition: *Destroy* QA: N/C Closed: *OK* Date: 11/06/10

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-04-29	100	Weaplate holes off center line at Fwd end interfering w/Fwd pc. Re; Process/Loc of attention	<i>DP</i> 11.04.19	<i>Scrap tube</i>	<i>DP</i> 11-4-29/11-04-29	<i>BB</i>	<i>DP</i> 11.04.19 PST/VR	<i>S</i> 11.06.09

NOTE: Date & initial all entries

Work Order ID 68648

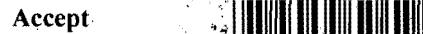
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Item ID: D3391-023

Accept



Setup Start



Revision ID:

Item Name: Mid-Tube Assembly

Start Date: 4/19/2011 Start Qty: 1.00



Required Date: 5/20/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Open .375" holes to .438" ***do not open fwd saddle holes***

DP

11-4-26

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drilled .188" dia hole, using t-pins and clicos to ensure perfect alignment, open up previously transferred pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drill remaining 6 wearplate holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
*							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68648

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Item ID: D3391-023

Accept



Setup

Start



Revision ID:

Item Name: Mid Tube Assembly

Stop



Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

110



QC

Quality Control

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC5- Inspect part completeness to step on W/O

0.00

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 68648

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Item ID:	D3391-023	Accept		Setup	Start				
Revision ID:									
Item Name:	Mid Tube Assembly								
Start Date:	4/19/2011	Start Qty: 1.00		Cust Item ID:					
Required Date:	5/20/2011	Req'd Qty: 1.00		Customer:					
Reference:									
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start			
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop			
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: _____ batch#: _____								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68648

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Item ID: D3391-023

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Setup Start



Revision ID:

Item Name: Mid Tube Assembly

Stop



Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Quality Control

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

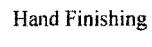
185



Pressure Wash per QSI005 4.3

0.00

HandFinish



Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68648

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Item ID: D3391-023

Accept



Setup

Start



Revision ID:

Item Name: Mid Tube Assembly

Stop



Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68648

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Item ID: D3391-023

Accept



Setup Start



Revision ID:

Item Name: Mid Tube Assembly

Stop



Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

210

Operation
Description

Skidtubes

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Memo

0.00

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

220



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68648

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Item ID: D3391-023

Accept



Setup

Start



Revision ID:

Item Name: Mid Tube Assembly

Stop



Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



HandFinishing

HandFinish

Memo

0.00

0.00

Hand Finishing

Install Inserts as per Dwg

240



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

250



Identify as per dwg & Stock Location:_____

0.00

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68648

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Item ID: D3391-023

Accept



Setup

Start



Revision ID:

Item Name: Mid Tube Assembly

Stop



Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

260

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

MP
11-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, April 19, 2011 1:31:01 PM

Work Order ID: 68648



Parent Item: D3391-023



Parent Item Name: Mid Tube Assembly

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A 05.10.20 New Issue
IPP B 06.02.10 ECN773 dwg rev.D
IPP C 07.03.20 rev F dwg
IPP D 07.03.28 re-format
IPP E 07.10.31 ecn 1053P
IPP Rev:F ECN 1056 07-11-13 DD verified by: EC
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP
Rev:J add in seq 140 expire date & sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100 		Manufactured	No			100	Each	104.0000	1	1			
Skidtube Extrusion													11-4-26
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				HALL	37065 50251		104 22 82		1				
D3391-021 		Manufactured	No			100	Each	0.0000	1	1			
Fwd Tube Assembly													
D3389-1 		Manufactured	No			140	Each	0.0000	1	1			
Web													
D3681-1 		Manufactured	No			160	Each	9.0000	5	5			
Spacer													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					LG001		9						
					65990		9						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, April 19, 2011 1:31:02 PM

Work Order ID: 68648



Parent Item: D3391-023



Parent Item Name: Mid Tube Assembly

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3591-1



Manufactured No

210

Each

59.0000

2

2



Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST068	59	_____
57350	22	_____
66147	37	_____

ALS4-1032-130



Purchased No

230

Each

1,950.000

20

20



Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	1950	_____
117331	1950	_____

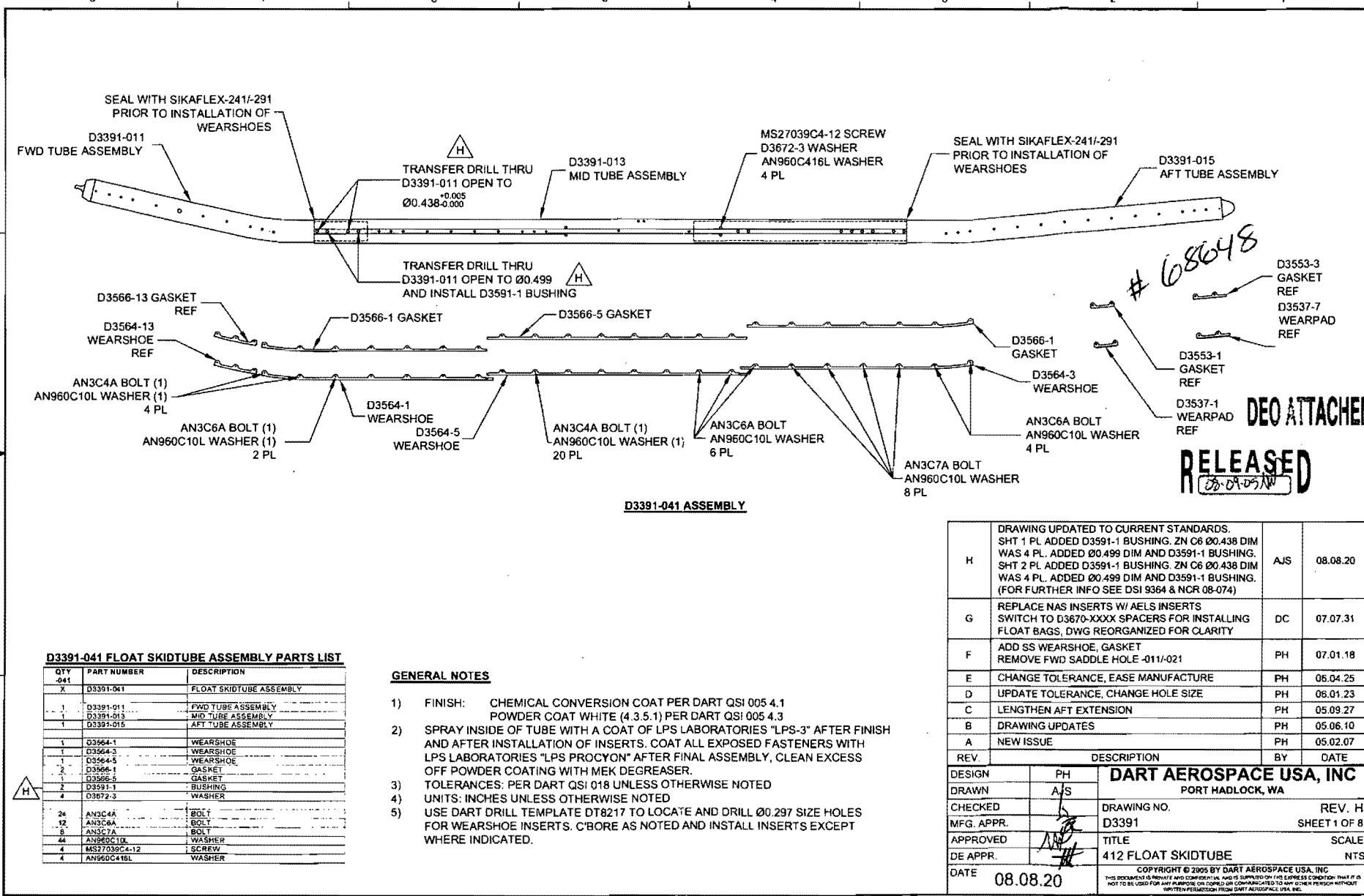
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

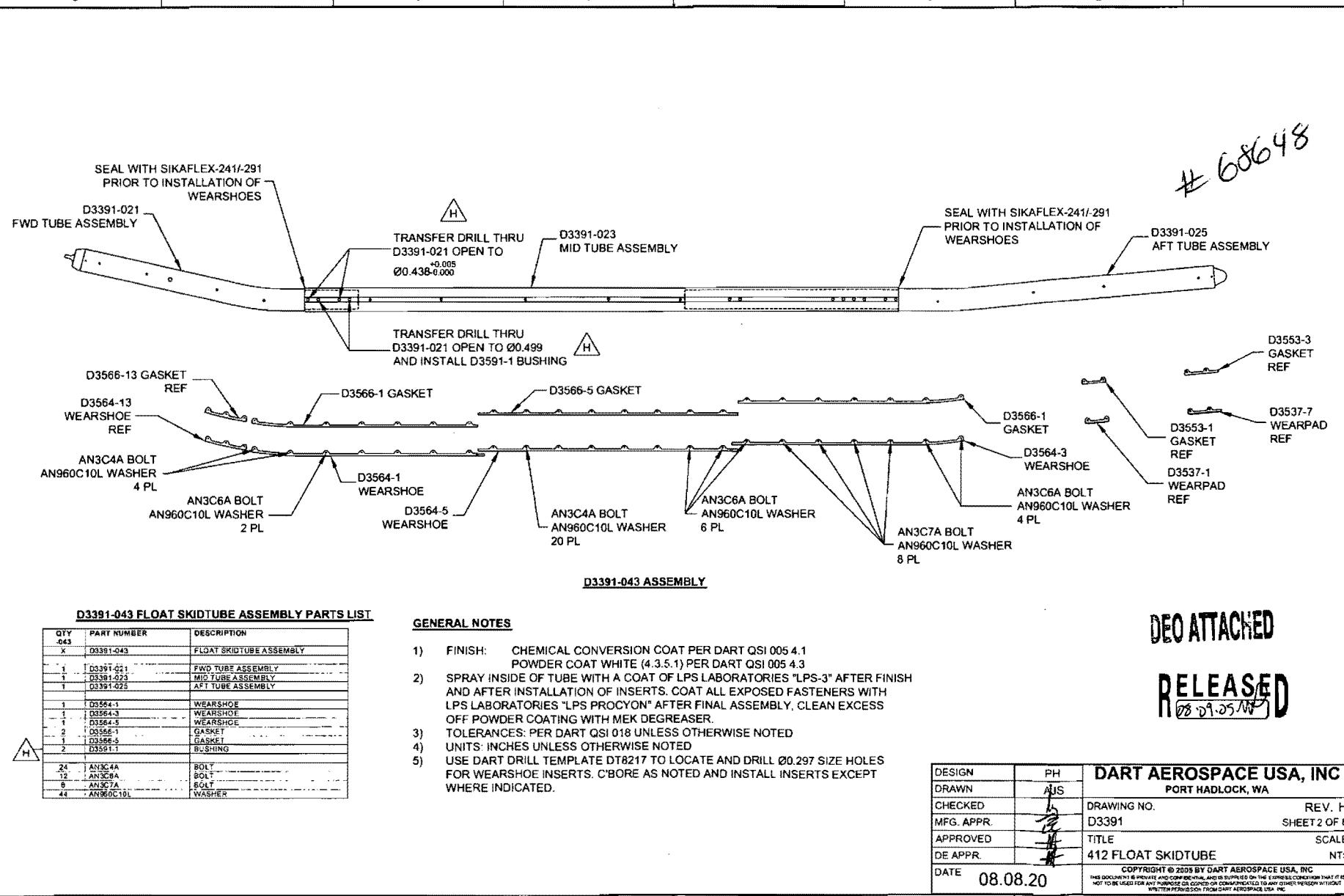


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

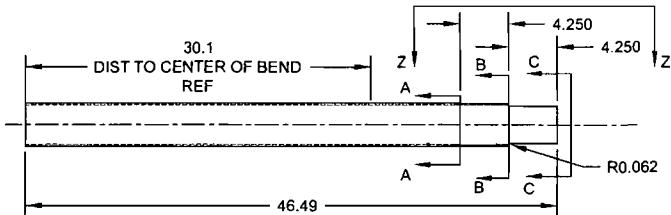
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

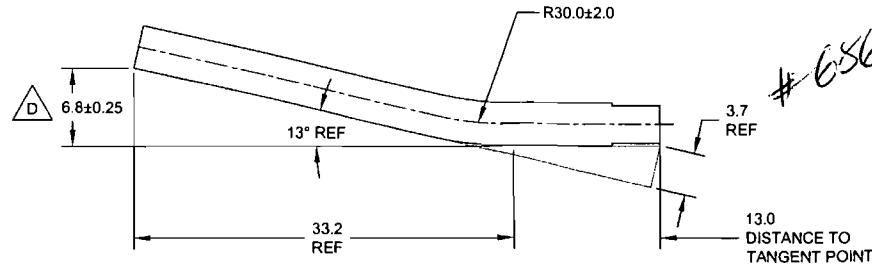
8 7 6 5 4 3 2 1

D



D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

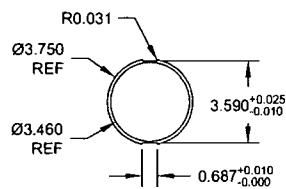
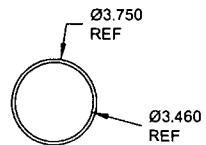
C



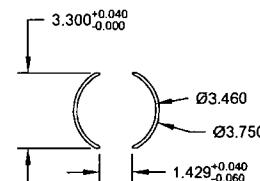
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

B

SECTION A-A
SCALE 2X

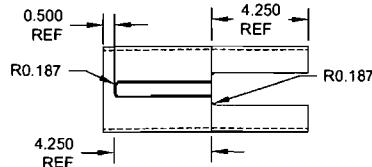


SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

A



VIEW Z-Z
SCALE 2X

DEO ATTACHED

RELEASED
09.05.14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>AS</i>	D3391	SHEET 3 OF 8
APPROVED	<i>JW</i>	TITLE	SCALE
DE APPR.	<i>JW</i>	412 FLOAT SKIDTUBE	NTS
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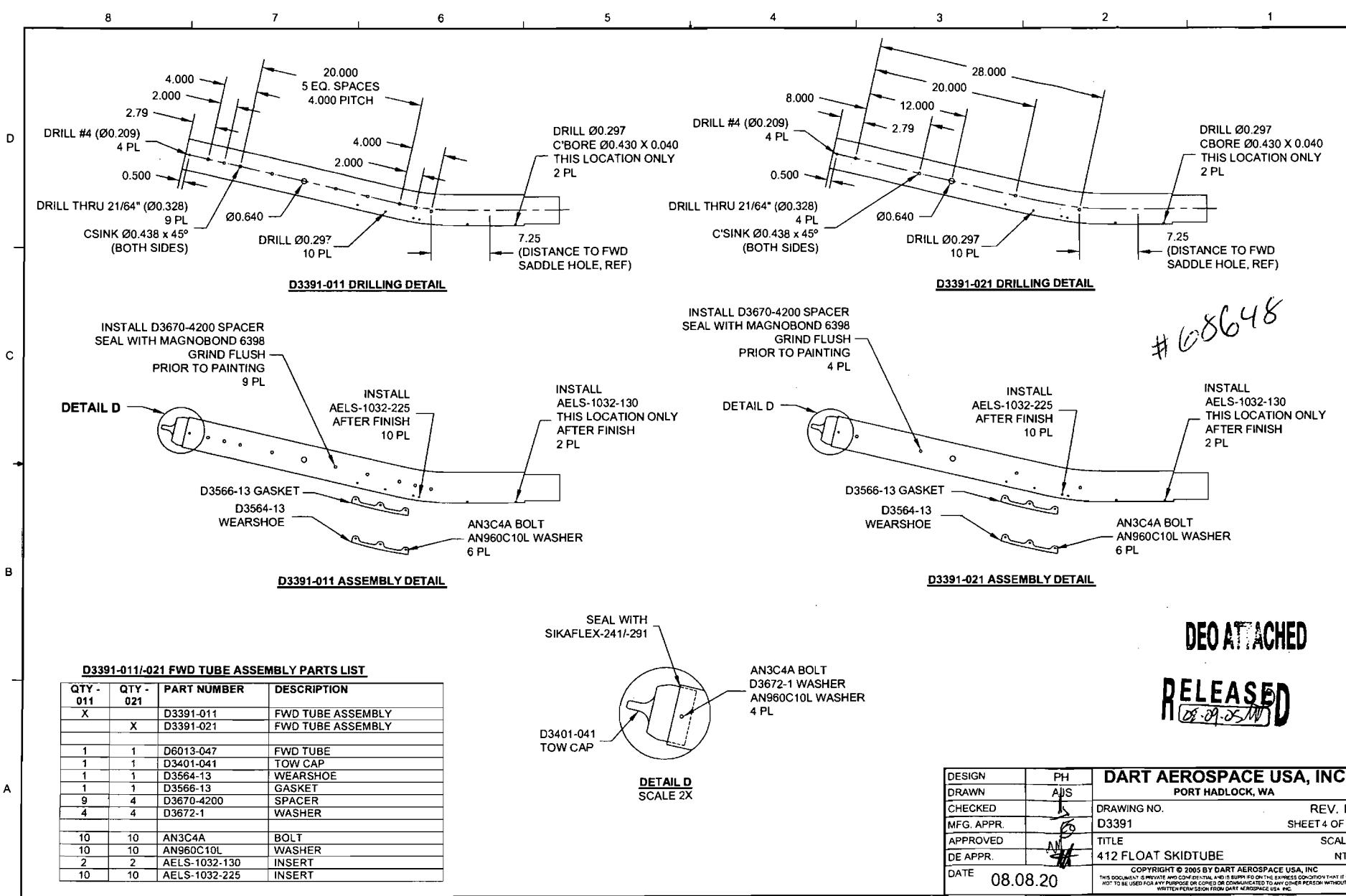
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



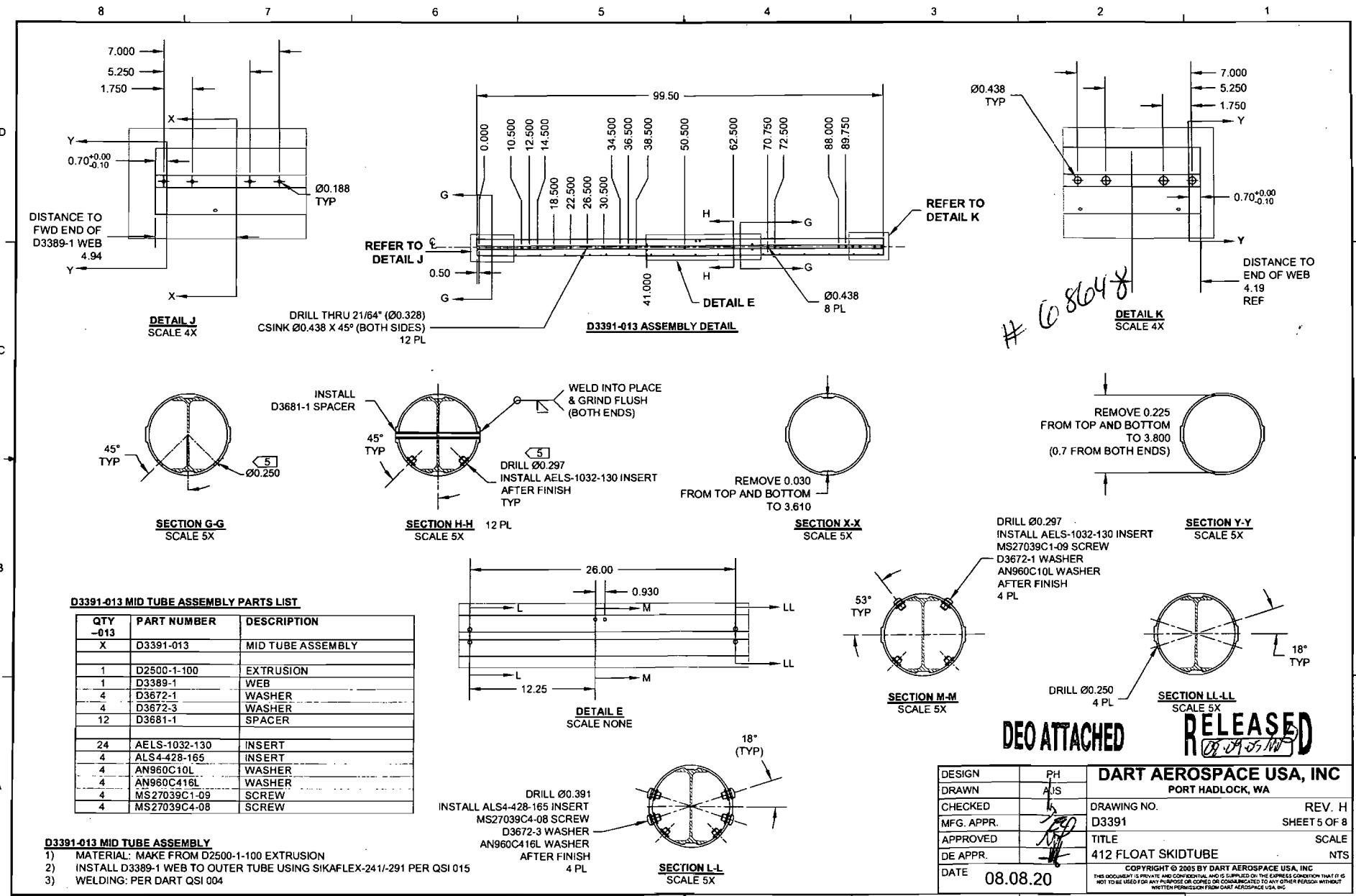
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NOTE: Date & initial all entries



DEO ATTACHED

RELEASED
09-05-2014

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. H	
MFG. APPR.	<i>[initials]</i>	D3391	SHEET 5 OF 8	
APPROVED	<i>[initials]</i>	TITLE	SCALE	
DE APPR.	<i>[initials]</i>	412 FLOAT SKIDTUBE	NTS	
DATE	08.08.20			

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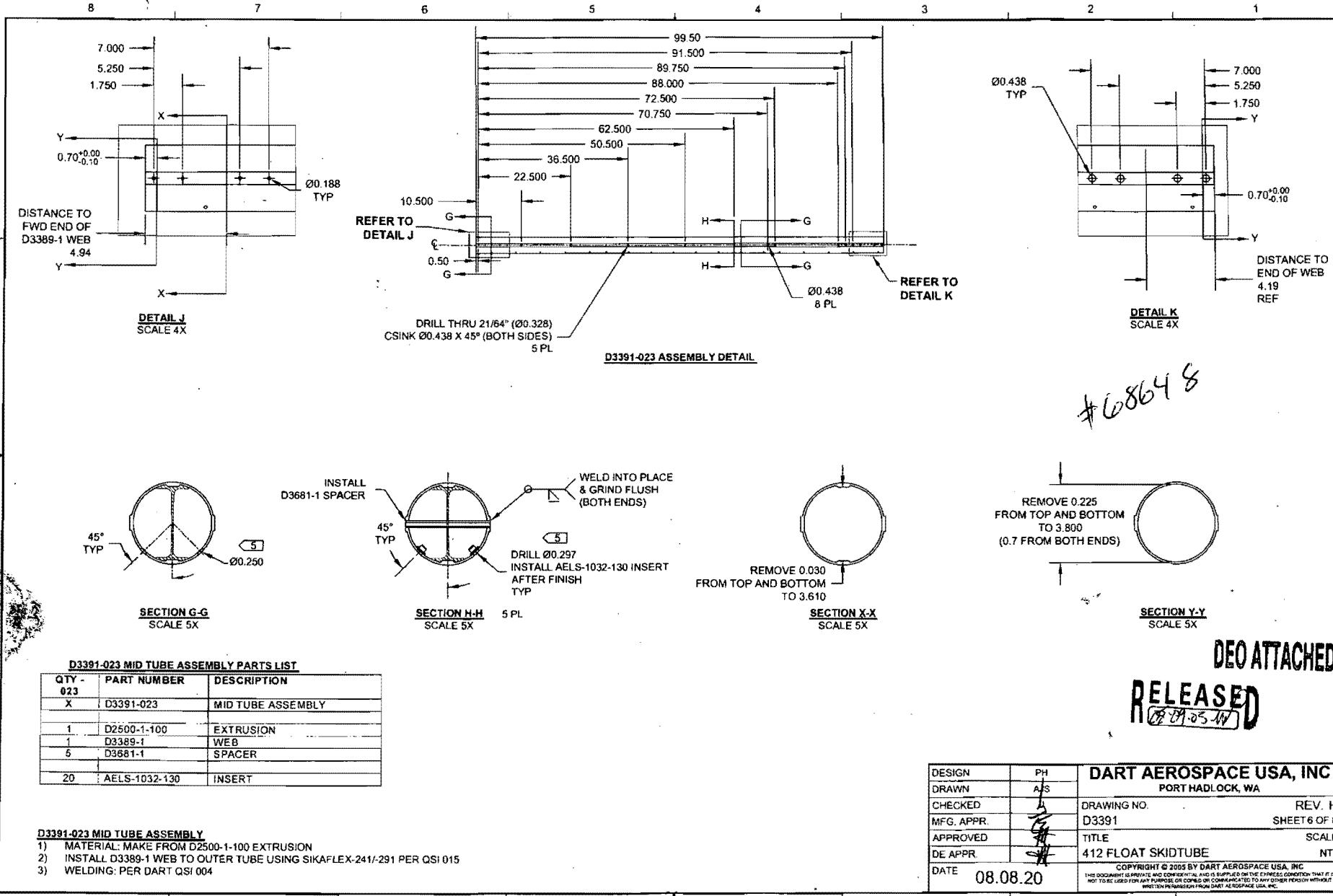
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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#68648
DEO ATTACHED

08.08.20
RELEASED

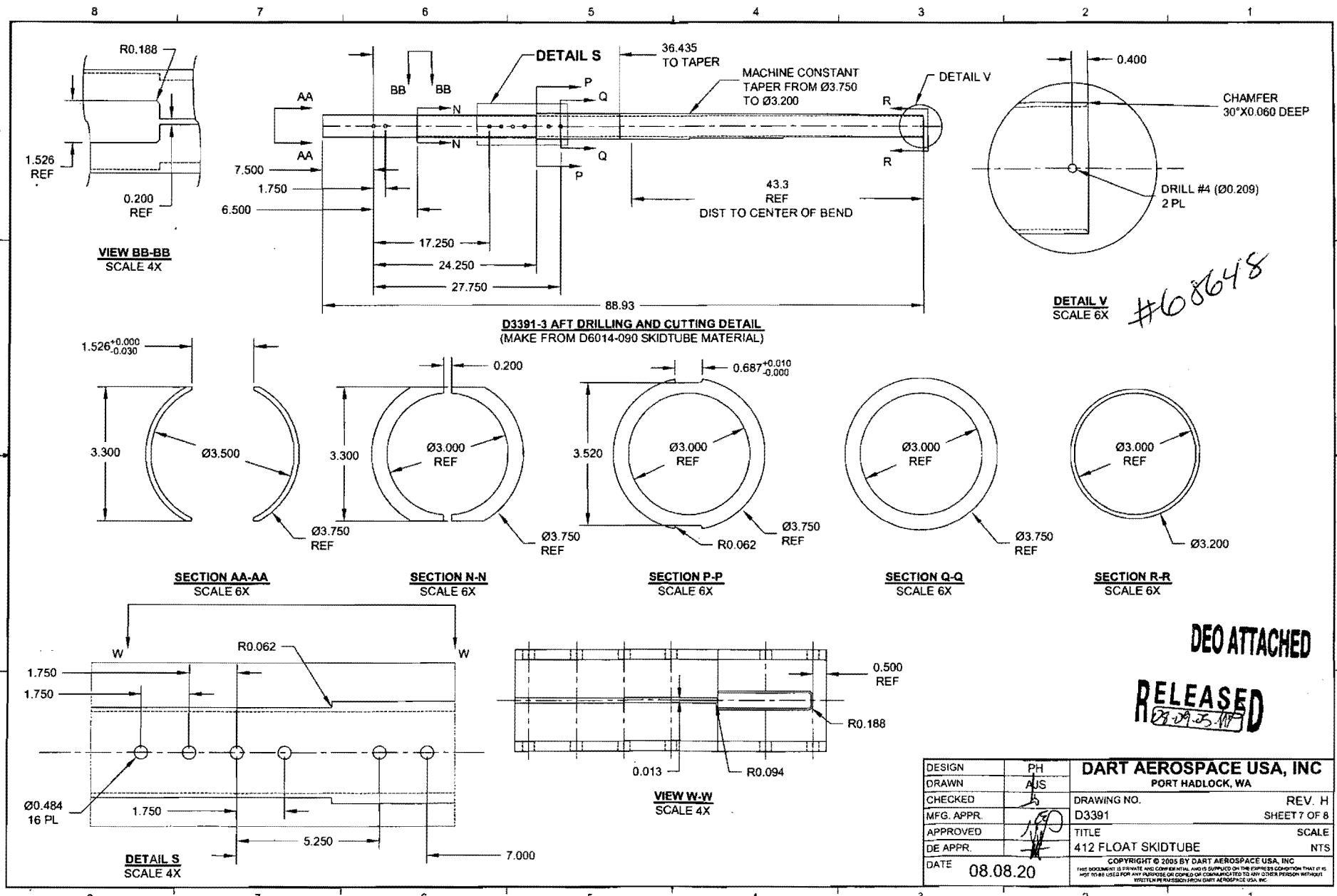
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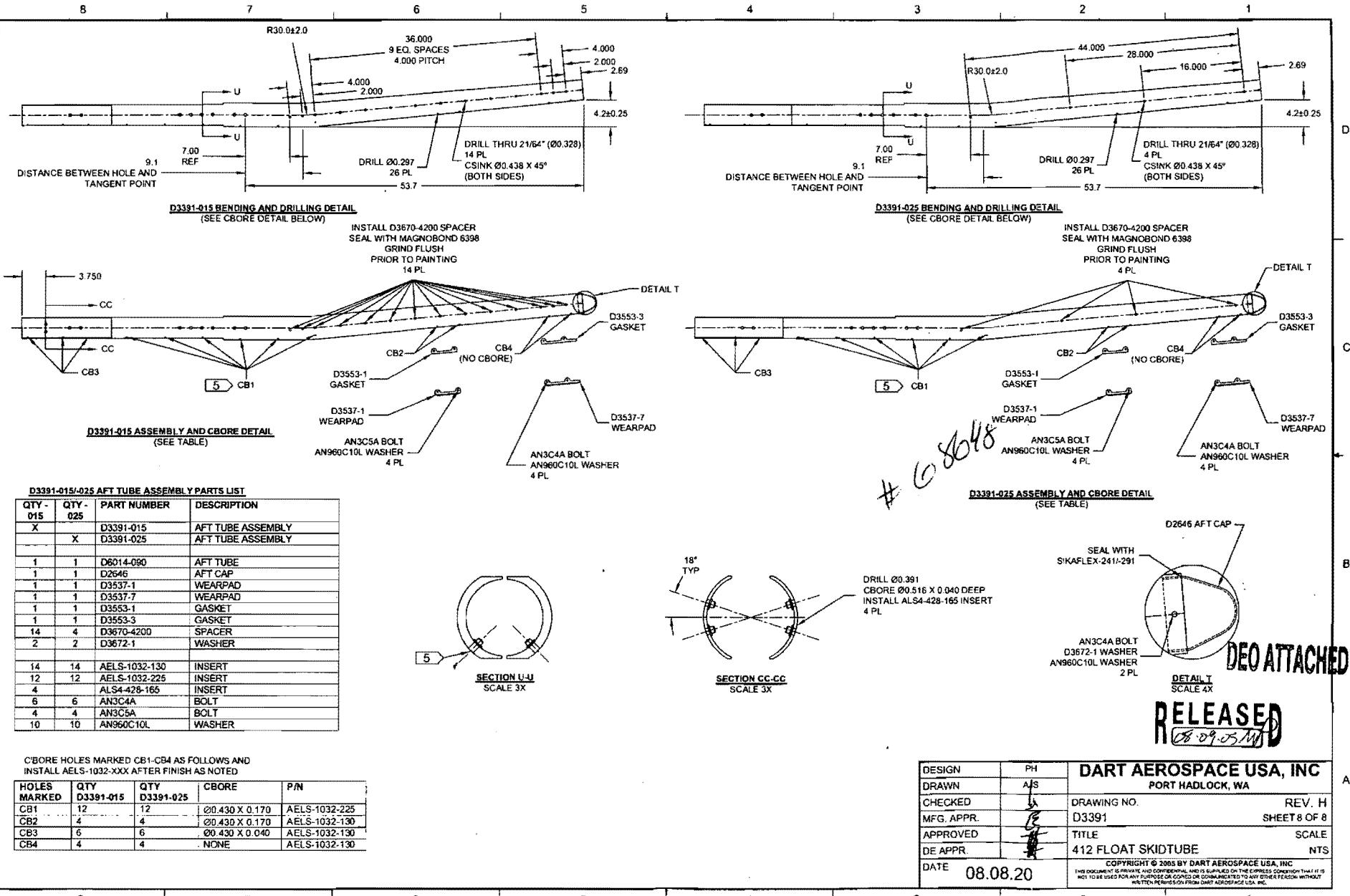
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C BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	.00 .430 X .0170	AELS-1032-225
CB2	4	4	.00 .430 X .0170	AELS-1032-130
CB3	6	6	.00 .430 X .0040	AELS-1032-130
CB4	4	4	.NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. H	
MFG. APPR.		D3391	SHEET 8 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	NTS	
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DRAWING NO.	TITLE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D3391	412 FLOAT SKIDTUBE			D3391-H-1	SHEET 1 OF 1	NTS
DRAWN	CHECKED		MFG. APPR.	APPROVED	DE APPR.	
09.09.23	04.04.24		09/09/25	09/09/30	09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

#68648

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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